

AWC - 019



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POSITIVE RECALL
EFFECTIVE 1/10/24 AUTH SLP
RELEASED 1/10/24 DATE 1/10/24
DAS 55
9-89

6F9540V00231

Job Sheet R198311



Part No: 6F9540V00231

Job Qty: 1 pcs

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: New

Job Created: 7/24/19

Job Tracking No:

Due Date: 8/9/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

U/R
SLP 19/07/24

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		8/9/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

AP 19-7-25



Container No: S200536



Part: 6F9540V00231

Job No: R198311

Serial No/Batch: S200536

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 07/25/19

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115 Small Fab - 2 - B4B	1 pcs	8/9/19	0.00 1.00	Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
120 Conventional Mill - 1 - B4B	1 pcs	8/9/19	0.25 0.33	Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	AB 19-7-25
				Small Fab - 7 - B4B	
				Conventional Mill - 1 - B4B	DAS 52 19/07/25
				Conventional Mill - 2 - B4B	9-89
125 QC 5	1 pcs	8/9/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS JUL 26 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130 Outsource - 4 - Anodize	1 pcs	8/9/19	0.00 0.00		JR
135 Packaging 2-1 - Receive - B4B	1 pcs	8/9/19	0.00 0.00	Packaging 2 - 1 - B4B	NR
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	

					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
140 QC 6	1 pcs	8/9/19	0.00 0.00	QC 6 - 9	NR	
				QC 6 - 68		
				QC 6 - 61		
				QC 6 - 40		
				QC 6 - 81		
145 Small Fab - 3 - B4B	1 pcs	8/9/19	0.00 0.50	Small Fab - 1 - B4B		
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B	A3 19-7-29	
				Small Fab - 7 - B4B		
150 QC 5	1 pcs	8/9/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40	JUL 29 2019 DAS 40 9-89	
				QC 5 - 61		
				QC 5 - 81		
170 QC 4	1 pcs	8/9/19	0.00 0.00	QC 4 - 28		
				QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9	DAS 75 9-89	
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72	AUG 02 2019	
				QC 4 - 74		
				QC 4 - 75		
180 Packaging 3-1 - Stock - B4B	1 pcs	8/9/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B	DAS 75 9-89	
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B	AUG 02 2019	

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See
Munzel
for concession

DAS
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9-89

Aug 2, 2019

Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	

190 DC - 1 - B4B	1 pcs	8/9/19	0.00 0.00
200 QC 21 - FG	1 pcs	8/9/19	0.00 0.00

DC - 1 - B4B	
DC - 2 - B4B	
QC 21 - FG - 21	
QC 21 - FG - 70	
QC 21 - FG - 53	

gk

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Part Op 110 - PULL FROM STOCK

Descriptions: 115 - REMOVE D4842-041 OUT FROM KIT, DISASSEMBLE AND KEEP HARDWARE TO REASSEMBLE.

120 - FACE DOWN (0.005") EACH D4842 AS PER DWG AND DEBURR.

125 - QC5- Inspect part completeness to step on W/O

130 - Issue P/O : _____ AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED

145 - REASSEMBLE USING ORIGINAL HARDWARE AS PER DWG Assemble as per dwg and apply loctite 598 on all faying surfaces. *Assembled with new bolts and nuts. AB*

170 - (QC4- 100% Inspect kits for completeness)

180 - Identify and pack for shipping as per PPP 6F9540V00231

190 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
6F9540V00231	AW169 Lower Cutter Installation Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5177409

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	6F9540V00231	1	4	0

Part Specifications

Specifications could not be found.

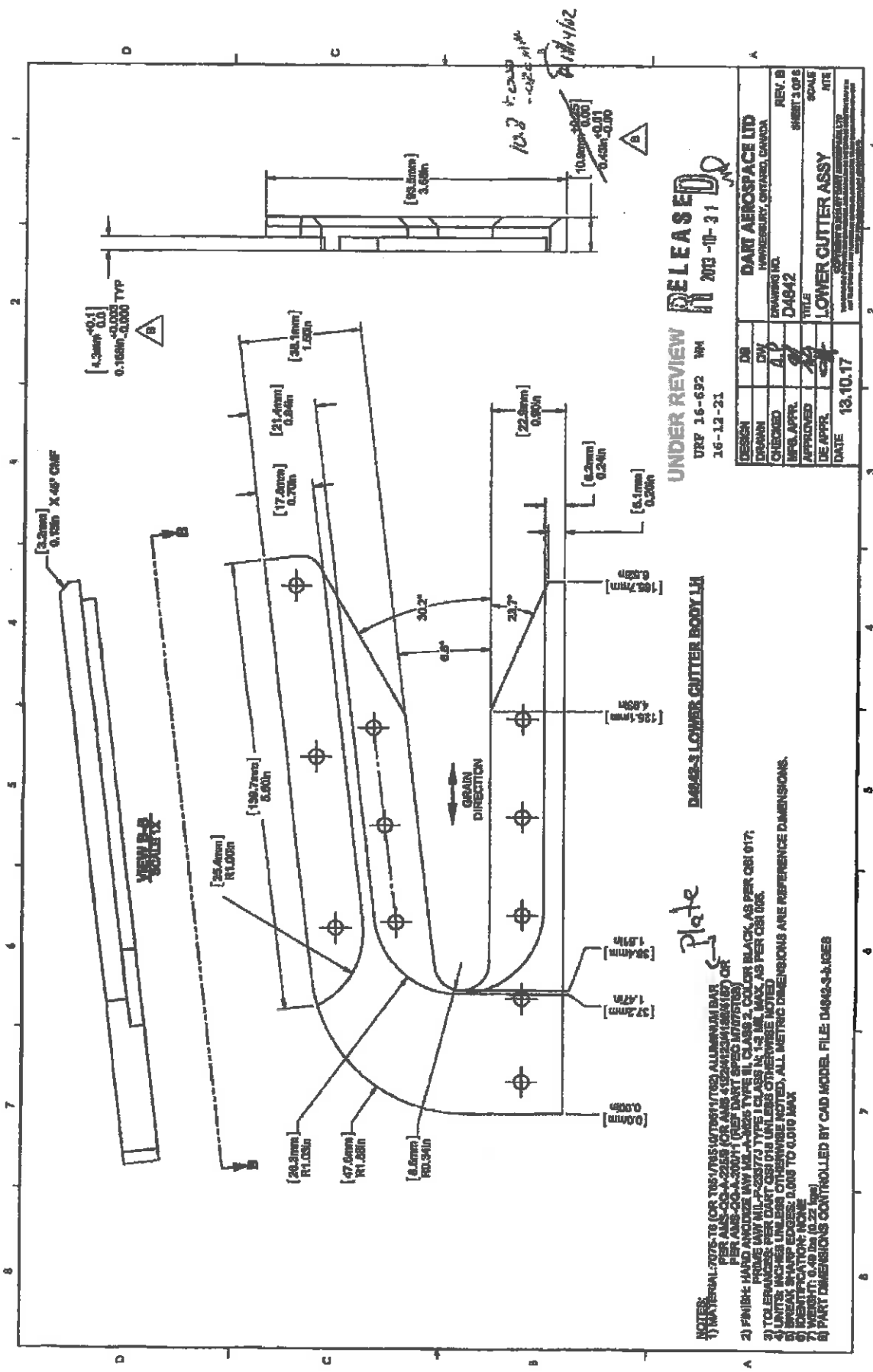


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Inventory

Operation Number	Operation	Container No	Job	Master Unit Number	Quantity	Weight	Serial No/Batch	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No	Expiration Date	Invent Type
Part Number: 6F9540V00231 Revision: AW169 Lower Cutter Installation Assembly																	
200	QC 21 - FG	S171709	192034		1 pcs	0	S171709	GA026		Stock	4/11/2019	*					False
		S195550	192031		1 pcs	0	S195550	Concession	Bin	Stock	7/3/2019	*			CHG002		False
		S195594	192032		1 pcs	0	S195594	Concession	Bin	Concession	7/3/2019	*			CHG002		False
		S195595	192030		1 pcs	0	S195595	Concession	Bin	Concession	7/3/2019	*			CHG002		False
Operation Totals:		4			4	0											
Part Totals:		4			4	0											
Totals:		4			4	0											

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UNDER REVIEW
 DART AEROSPACE LTD
 16-12-21
 16-12-21

DESIGN	DATE	13.10.17
DESIGNED	DATE	13.10.17
DRAWN	DATE	13.10.17
CHECKED	DATE	13.10.17
INSP. APPL.	DATE	13.10.17
APPROVED	DATE	13.10.17
DE APPR.	DATE	13.10.17
TITLE	DATE	13.10.17
REV. B	DATE	13.10.17
SHEET 3 OF 8	DATE	13.10.17
SCALE	DATE	13.10.17
NOTE	DATE	13.10.17

D4943-3 LOWER GUTTER BODY L1

Plate

- NOTES:
- 1) MATERIAL: 7075-T6 (OR T65/T651/T6511/T652) ALUMINUM BAR PER AMS-QQ-A-2258 (OR AMS 4132/4133/4134/4135) OR PER AMS-QQ-A-22011 (REF. DART SPEC. M717515)
 - 2) FINISH: HAND ANODIZE MIN 12.1-12.25 TYPE II, CLASS 2, COLOR BLACK, AS PER CSI 017.
 - 3) TOLERANCES: PER DART Q81 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: MILLIMETERS (MIL) UNLESS OTHERWISE NOTED
 - 5) SURFACE: SHARP EDGES, 1.000 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.40 lbs (0.22 kg)
 - 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4943-3-1.DWG

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: <u>R199311</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>6F954000021</u>		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____	Sequence #: _____	QTY Affected: _____		Disposition		Completed By <u>3C</u> <u>19/07/25</u> Lead hand/ Supervisor <u>Ant</u> <u>19/07/25</u>	
Description Work Order Deviation		Disposition		QC / QA Coordinator			
Remove 0.005 of Material from base face for the following Parts 04842-3 and 4842-4 (see attached Drawing) Measurement SA, 0.425 0.000 + 0.002- also at assembly use bolt 3x and washer 3x at base of cable cutter - tighten snug for the time being when Sealant dries up, the remove bolts and overhand		re-work 04842-041 as per attached instruction/drawing					
Root Cause		FAULT CATEGORY					
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐	
Human Factors ☐		Other/Details: _____		Positioned Wrong ☐		Outside Tolerance ☐	
				Drawing ☐		Finish ☐	
				Part Lost/Missing ☐		Misread ☐	

